

54559 DRW

Work Order ID 53119



October 22, 2009 12:53:14 PM

Item ID: D3072-1

Accept



Setup Start



Revision ID: A1

Stop



Item Name: Bracket

Start Date: 22/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: PL

Date: 09-10-27 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3072

Rev A1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3072 (D3072-101 flat pattern) ☐ Dwg
Rev: A1 ☐ Prog Rev: A1 ☐ 2-Deburr if necessary

13 9-10-27

(12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

13 9-10-27

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

27 502/10/28

(412)

Work Order ID 53119

October 22, 2009 12:53:14 PM



Page 2

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

0.00

09/12/07

12

Small Fab

Memo

0.00

Small Fab

1- deburr if necessary 2- Bend as per dwg D3072

140



QCS- Inspect part completeness to step on W/O

0.00

09/12/10

412

QC

Memo

0.00

Quality Control

150



Chemical Conversion Coat per QSI005 4.1

0.00

09-12-10

12

HandFinish

Memo

0.00

Hand Finishing

Work Order ID 53119

October 22, 2009 12:53:14 PM



Page 3

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

M 109091

Memo

0.00

12-09-12-11

(12)

Powder Coating

START TIME:

10:05

OVEN TEMPERATURE:

320° FINISH TIME:

10:35

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

11-04-12-10

(112)

Quality Control

180

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

9/12/11 (1225)

Packaging

Work Order ID 53119

Page 4

October 22, 2009 12:53:14 PM

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Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/14

OK 0912-4
(12)

Picklist Print

October 22, 2009 12:53:22 PM

Page 1

Work Order ID: 53119

Parent Item: D3072-1RevA1

Parent Item Name: Bracket



Comments:

Start Date: 22/10/2009

Required Date: 30/10/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.090		Purchased	No			100	sf	73.5000	1.2284	1.500		
<div>   </div>												
5052-H32 .090 Sheet												

18910-27

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	73.5	
100782	41.5	
3019	32	

100782

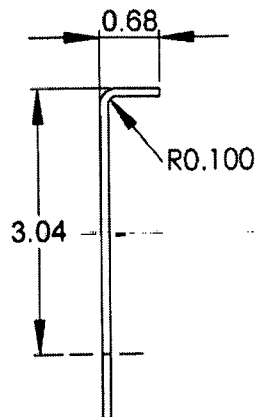
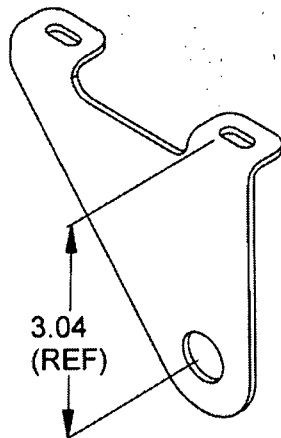
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 53119
R09-10-22

DART



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3072	REV. A SHEET 1 OF 1
DATE 01.12.16	TITLE BRACKET SCALE 1:1		
A	01.12.16	NEW ISSUE	
AI 02.01.18		ADD FLAT PATTERN PART NUMBER # CP	



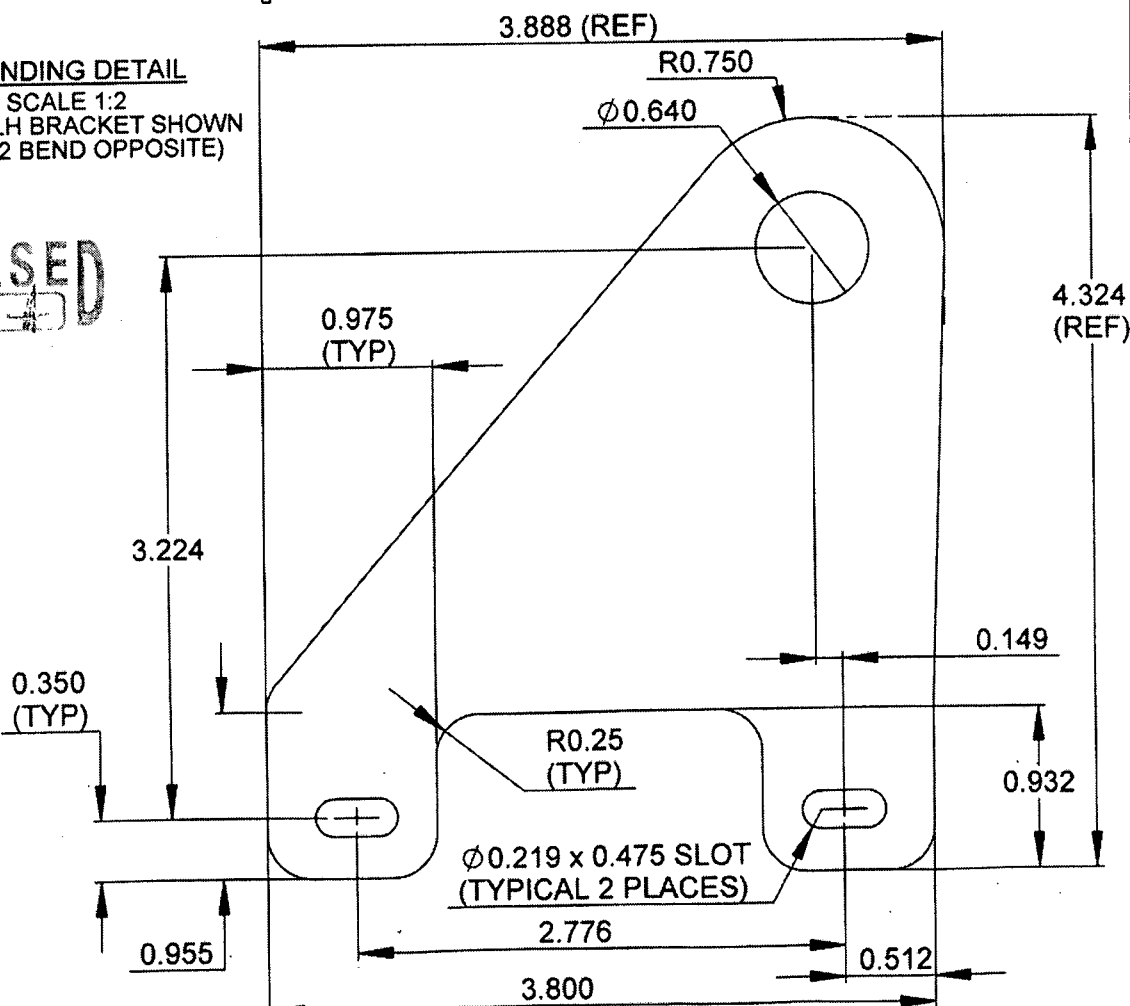
D3072-1/-2 BRACKET

- 1) MATERIAL: 5052-H32/H34 (AMS 4016/4017/
QQ-A-250/8) 0.090 THICK
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7)
PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

BENDING DETAIL

SCALE 1:2
D3072-1 LH BRACKET SHOWN
(D3072-2 BEND OPPOSITE)

RELEASED
02.01.15



D3072-101

FLAT PATTERN FOR D3072-1/-2

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